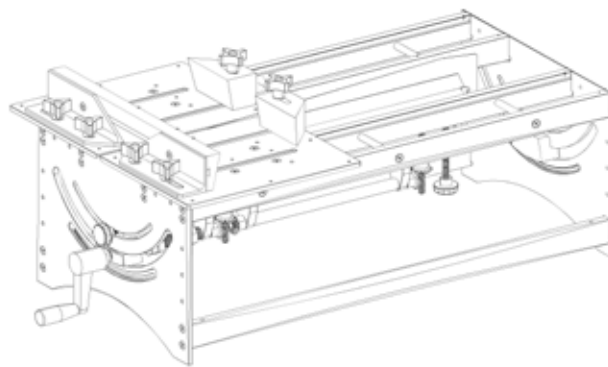


4th Edition

SIGNATURE SERIES

JOINTMASTER PRO



USER'S GUIDE

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IMPORTANT: READ FIRST!

Thank you for your purchase of the Jointmaker Pro!

Your experience with this innovative new tool should be nothing but positive. Towards that objective we are asking you to contact us with any questions regarding assembly or use of the Jointmaker Pro. We can be reached by either phone or email:

1.800.253.3332

*John Economaki: john@bridgecitytools.com
(JM-P inventor)*

*Michael Berg: michael@bridgecitytools.com
(Production Manager/Designer/Woodworker)*

*We have also created a forum dedicated to the Jointmaker Pro for fellow owners to share and exchange ideas;
<http://www.bridgecitytools.com/discussion/>*

We recommend you visit this forum periodically for exciting new ideas, tips and tricks. NOTE: This is a moderated forum and we will do our best to keep it positive, exciting and a useful resource.

OVERVIEW

The Jointmaker Pro is the world's first stationary hand cross-cut saw and will accurately allow you to make most of the cuts required in wood joinery plus a myriad of other sawing applications.

Consisting primarily of two independent linear tables mounted over specially designed, fine-toothed saw blades, the Jointmaker Pro redefines the meaning of "cut by hand." Using no electrical power, the Jointmaker Pro is designed specifically to make precision cuts for the most demanding craftspeople with as little noise as possible, and without the need for dust collection. Understanding how this tool works—what it can and cannot do—is your key to a successful and fruitful experience.

Cutting wood accurately by hand requires a great deal of practice and is difficult for many, particularly those new to the craft. With the Jointmaker Pro, people of all ages and experience levels can achieve results that are **MORE ACCURATE** than cuts made with power equipment. Furthermore, the cuts are unparalleled in quality creating opportunities for new and exciting ideas not possible with traditional techniques.

At this time, please take a few minutes and peruse the assembly section of this guide to become familiar with the nomenclature of the Jointmaker Pro. This will make the remainder of this section much easier to understand.

SAFETY

Your Jointmaker Pro is no different than any other sharp tool—use common sense!

Although it may seem safe to take risks because the saw blade is stationary—and the only motion is provided by YOU—safety should never be taken for granted.

Etched on the top of each sliding table is a graphic element that is designed to remind you of the risk to your fingers. It may seem obvious, but we strongly recommend keeping your fingers out of this zone, especially when the blade is tilted.

After you have spent an hour or two using the Jointmaker Pro we hope you share your new found ability with other members of your family—this tool can be enjoyed by many who like making gallery quality cuts in a noise free environment!

SAW RIGIDITY AND ERGONOMICS

Under all circumstances, the Jointmaker Pro needs to be firmly anchored to a work surface or attached to a stand. If the saw moves while cutting your accuracy and enjoyment of the tool will be less than optimal.

The front table height of the Jointmaker Pro should be an inch or so below your belt line. At this height, you will be able to make a full stroke without undue stress on your back or arms. If possible, we recommend that the rear of the Jointmaker Pro be approximately three inches higher than the front. This incline shortens the stroke of your arms, increases your ability to see your work and reduces strain on your lower back during long work sessions.

WORK HOLDING REQUIREMENTS

Traditionally when cutting wood with a hand saw you clamp the material to be cut to a workbench or hold your stock in a vise. With either method, the stock should always be firmly anchored in order to achieve optimal, and accurate, results.

The same work holding requirements are true when making most cuts with the Jointmaker Pro. The sliding table is analogous to a workbench surface and the angled trap clamps act as a vise. These elements become particularly crucial with the Jointmaker Pro because unlike any other hand sawing experience, you are cutting from the bottom up as opposed to top down. Without your stock firmly anchored to the sliding tables, the negative feed (the tendency of the wood to ride up over the top of the blade) becomes difficult to manage with hand strength alone. In almost all cases, we strongly recommend that you utilize these work holding aids for accuracy and blade longevity. When using the blade in a tilted position, trap clamping is mandatory.

SAW BLADES & DEPTH OF CUT

All of the saw blades currently designed for the Jointmaker Pro contain between 350 and 460 teeth over their length. Because the blade is inclined (the front of the blade is lower than the back of the blade) in relation to the table surfaces, each tooth bears the exact same workload.

For example, a piece of walnut with a 1/2" x 1/2" cross-section can be cut in half with one stroke using the standard crosscut blade. To correctly set the blade for this cut, you would adjust the blade so that the first couple of teeth are below table height, and the last tooth of the saw blade is set with the pitch adjuster to approximately 1/32" above the stock of the wood. With the stock held firmly against the fence, one stroke and the cut is complete, smooth and accurate. *See the Cutting Guide page 20 for more details.*

This example is possible because the standard JM-P crosscut blade has approximately 400 teeth. Using the stock and set-up described above, each tooth of the saw has a chip load of just over one one-thousandth of an inch ($.5/400 = 0.00125$ "). It is the combination of the chip load, precise linear movement and blade rigidity that makes Jointmaker Pro cuts unparalleled in quality or accuracy.

For wider stock (where more teeth are simultaneously engaged with the stock), multiple passes are required utilizing a smaller depth of cut per pass.

For example, 1/2" thick walnut 4" in width would dictate that you set the saw up with the first couple of teeth below table height (using the hand crank at the front of the JMP) and the last tooth approximately 1/16" above the table (using the Pitch Adjustor). With this set-up, it will take 8 passes to cut the stock in half. Between each pass the blade is raised approximately 1/16". In this situation, the 400 teeth are required to cut approximately 1/16th of material per pass. The chip load is now one ten-thousandth of an inch ($.0625/400$) per tooth! However, because the board is 4" in width, more teeth are engaged during each pass creating more resistance. More resistance requires smaller bites for the cuts to feel almost effortless.

The only "guide" we can provide for tailoring your technique to accommodate the myriad of different species and sizes of wood is to emphasize that the effort required to cut any wood should be minimal. Harder material or wider stock requires smaller bites and more passes. If you are overly aggressive, you will dramatically shorten blade life and the quality of your cuts will suffer. After a short "getting acquainted" period all of this will become second nature.

As a reference, one full revolution of the crank handle raises the blade exactly .055" or slightly less than 1/16". You will discover that extremely dense woods will require blade height adjustments as small as 1/8 of a revolution between cuts and some softwoods can be cut with 3 full revolutions for each pass! It is your job to discover the optimal settings for ease of use according to your own preferences and applications.

You will soon discover the general purpose cross-cut blade that ships with the JM-P will do the majority of cuts (.4mm x 28). The 16 tooth rip blade is useful for cutting tenons and dovetails if you have many to cut. The .3mm crosscut is ideal for small stock but does not track well in deep cuts (it is so thin it will follow the density changes of the wood being cut).

You will know when your blade is dull because of the resistance you sense with cutting or the quality of the cut is not smooth to the touch. Blades are not designed to be sharpened—they are disposable. Replacement blades can be found at; www.bridgcitytools.com or by calling 1-800-253-3332.

NOTE: Please visit www.bridgcitytools.com to view the Jointmaker Pro videos!

THE FENCES AND HAND PLACEMENT

The Jointmaker Pro utilizes two fences that are normally bridged by a sacrificial wooden fence. The only time you do not use both tables is when you are cutting face miters.

There are two sacrificial fences, one is straight and the other has an angled face. Use the straight fence for joinery and the trap fence for crosscuts. We recommend the fences be locked in the forward position for all cuts of 4" or less in width. For stock wider than 4 inches, slide the fences to the back position.

When possible, your hands should be directly over the center of the dovetailed ways on each side of the saw blade. As your experience with the saw grows, you will learn that you can use one hand to make your strokes and the other will be raising the blade on the return stroke. This combination is efficient and fast.

We recommend that your first cuts be made with both hands employed during the sawing strokes.

NOTE: The table tops are orange for a reason; you can write on them with a pencil. For example, once you have the fence set to 90 degrees, you can scribe a pencil line along the fence and use this line as a reference. Please visit our website to view the video on how we set angles on the Jointmaker Pro.

STUPID MISTAKES WE HAVE MADE

We have ruined several blades because of human error. Please review this section to learn from our mistakes.

•**MAKE SURE THE KEEL, THE FENCES, AND YOUR CLAMPS are all TIGHT before sawing.** This will eliminate 80% of the mistakes we have made.

•Lower the blade below table height after each session. Horizontal surfaces attract things, and the blades are easily damaged with contact by metal objects or heavy wood.

•It is helpful to have an old toothbrush nearby to periodically clean wood fibers that may be embedded in the gullets of the blade. This is particularly helpful when using the rip blade.

•Lastly, enjoy the fact that you are the motor. Let the saw do the work and use as many passes as needed to accomplish your tasks. WE GUARANTEE that aggressive sawing techniques are going to be expensive for you.

LUBRICATION

Before EACH SESSION, we recommend you check the tables for slop (easy to fix—see step 19 on page 14) and lubricate the ways with a Teflon based dry-film lubrication. You want your tables to slide as smoothly as possible. For example, at trade shows, we lubricate the ways three or four times over an eight hour period.

Please review the lubrication guide on page 19 for all other lubrication locations (this is done once or twice a year depending on use.)

ASSEMBLY

Step-by-step assembly instructions are included in this Users Guide. Please contact us if you have any difficulties assembling the Jointmaker Pro. We also have posted on our website videos showing how we align the blade to the ways and proper table adjustments. They are not difficult to do but the videos may increase your understanding of these two important adjustments.

Your Jointmaker Pro is fully warranted for defects in workmanship. Please notify us immediately if you have encountered an effective component. We will replace it immediately.

CALIBRATION

LINEAR TABLE ADJUSTMENTS The Jointmaker Pro was designed to perform as quietly as possible. The two dovetailed aluminum rails on each side of the blade are fixed in place by the front and back plates—they are not adjustable. Underneath each sliding table are two acetyl dovetailed sliders. The slider closest to the saw blade on each table is fixed (non-adjustable). The acetyl slider furthest from the saw blade on each table is adjustable and when properly tensioned, both tables will slide smoothly without any lateral slop. You will periodically adjust the tension on these two ways over time for optimal performance—this process usually takes two or three minutes and is fully demonstrated in the assembly video.

SAW GUIDES The saw blade of the Jointmaker Pro moves up and down between two blade guides that literally pinch the blade. One guide is black, the other is blue. Once assembled, the blue guide is the only guide that is adjusted when changing between blades of different thicknesses. The black guide is never adjusted.

FRONT AND BACK PLATE TRAVELERS The saw blade and the components that raise and lower the blade are attached to an aluminum keel. The keel is attached to acetal travelers that allow the blade to tilt up to 45 degrees in either direction by riding in arcs milled into the front and back plates.

The two acetyl travelers must glide in the front and back plates without any slop. There are two nylon set screws in each traveler that allow for this adjustment. If these nylon set screws are not properly adjusted, the keel will not remain parallel to the ways.

YOUR FIRST CUT

Once your Jointmaker Pro is properly set-up, you are ready to make your first cut.

We recommend practicing your first cut on a small dowel rod, 1/4" – 1/2" in diameter. Set the leading edge of the crosscut blade slightly below table height, and using the pitch adjuster, raise the rear of the blade until it is slightly taller than your stock.

Before you make a cut, take a couple of "dry runs" to get a feel for the resistance of the tables in motion. When comfortable, hold your material firmly against the fence and with one smooth, controlled push, cut your stock. You will discover after just a few passes the rhythm required for incredible results. As the density/width of your stock changes, you will sense the need to reduce depth of cut and increase the number of passes. THERE ARE NO GUIDELINES other than to offer that the feedback you sense from the cutting action will dictate any adjustments you will need to make for effortless cutting.

We invite you to visit our website (www.bridgcitytools.com) to view videos of how we cut different materials.

YOUR EXPERIENCES WITH THE JOINTMAKER PRO MATTER!

Please share your experiences and ideas regarding the Jointmaker Pro with fellow users! This new and exciting tool is capable of extraordinary applications, some that may be understood only by dedicated users. Please share and/or inquire by participating in the user forums located at www.bridgcitytools.com.

Thank you again for your purchase of the jointmaker pro. please share pictures and stories with us as you employ this remarkable new tool in your shop!!



John Economaki
President

TOOLS REQUIRED FOR ASSEMBLY

A flat table surface is the best place to assemble the Jointmaker Pro.

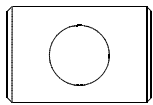
#2 Philips Head Screwdriver

Small Hammer

9/16" Open ended wrench or Adjustable Wrench

Needle Nose Pliers

FASTENER LEGEND



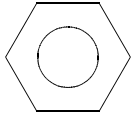
Pitch Screw Barrel Nut x 1



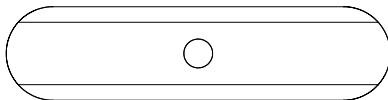
10-32 Nut x 6



6-32 Nut x 4



3/8-16 Jam Nut x 1



Dovetail Nut x 2



5-40 x 3/16" Philips Head Screw x 5



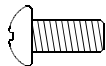
6-32 x 5/16" Button Head Cap Screw x 4



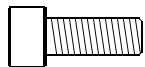
10-32 x 3/8" Socket Flat Head Screw x 2



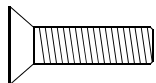
4-40 x 1/2" Socket Flat Head Screw x 1



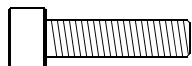
8-32 x 3/8" Philips Head Screw x 4



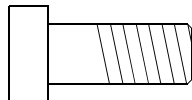
10-32 x 1/2" Socket Head Cap Screw x 4



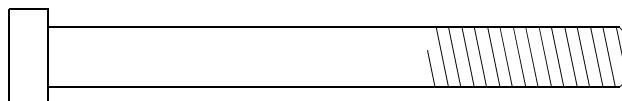
10-32 x 3/4" Socket Flat Head Screw x 48



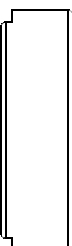
10-32 x 3/4" Socket Head Cap Screw x 20



5/16-18 x 3/4" Bolt x 4



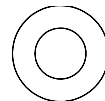
5/16-18 x 2-1/2" Bolt



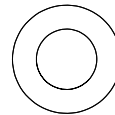
5/16-18 Pitch Adjustor with Screws and washers x 1



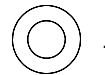
5/16-18 Left Hand Height Screw x 1



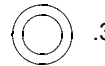
.684" OD Steel Flat Washers x 6



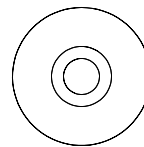
Acetyl Washers x 4



.354 OD Steel Washer x 20



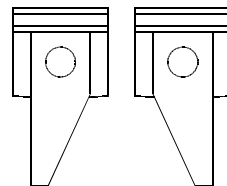
.310 Shim Washer x 2



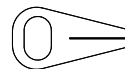
Rubber Bumper x 4



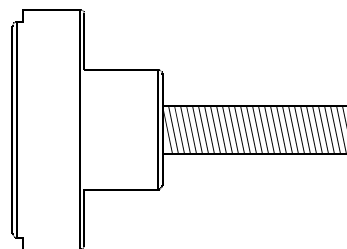
Spring Pin x 1



Finger Stops, Left and Right 2 each



Acrylic Indicator x 1

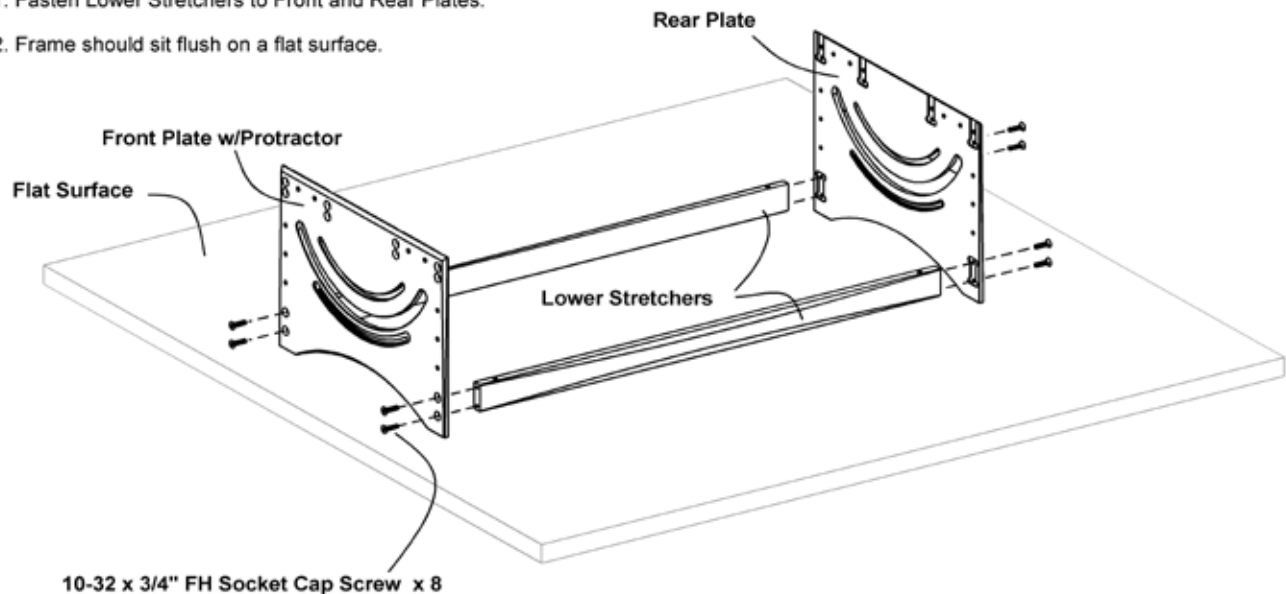


Keel Knobs x 2

1. FRONT & BACK PLATES

STEPS:

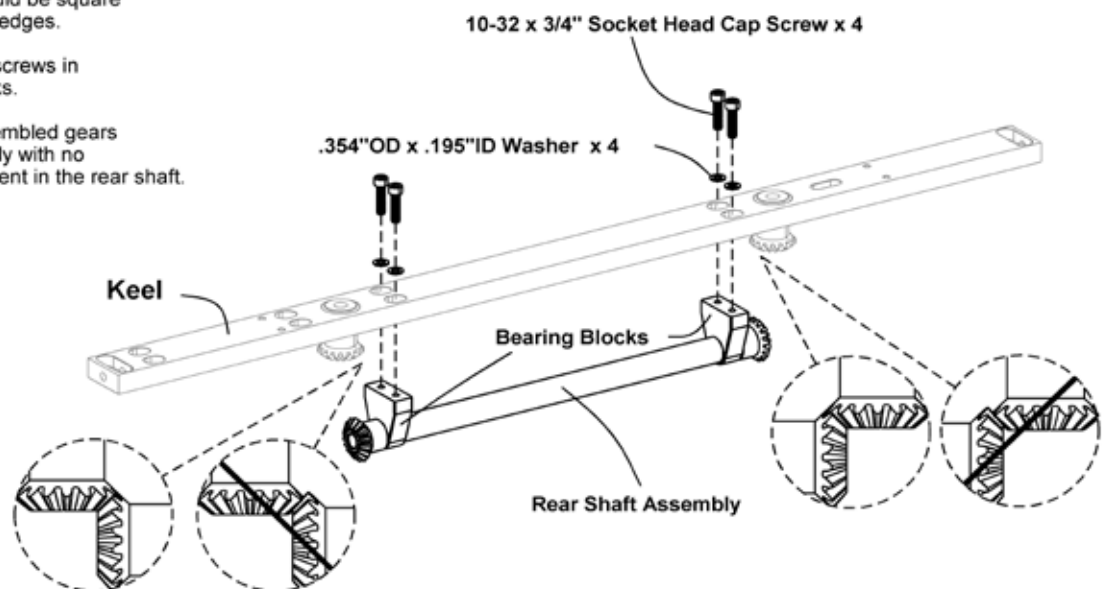
- ☐ 1. Fasten Lower Stretchers to Front and Rear Plates.
- ☐ 2. Frame should sit flush on a flat surface.



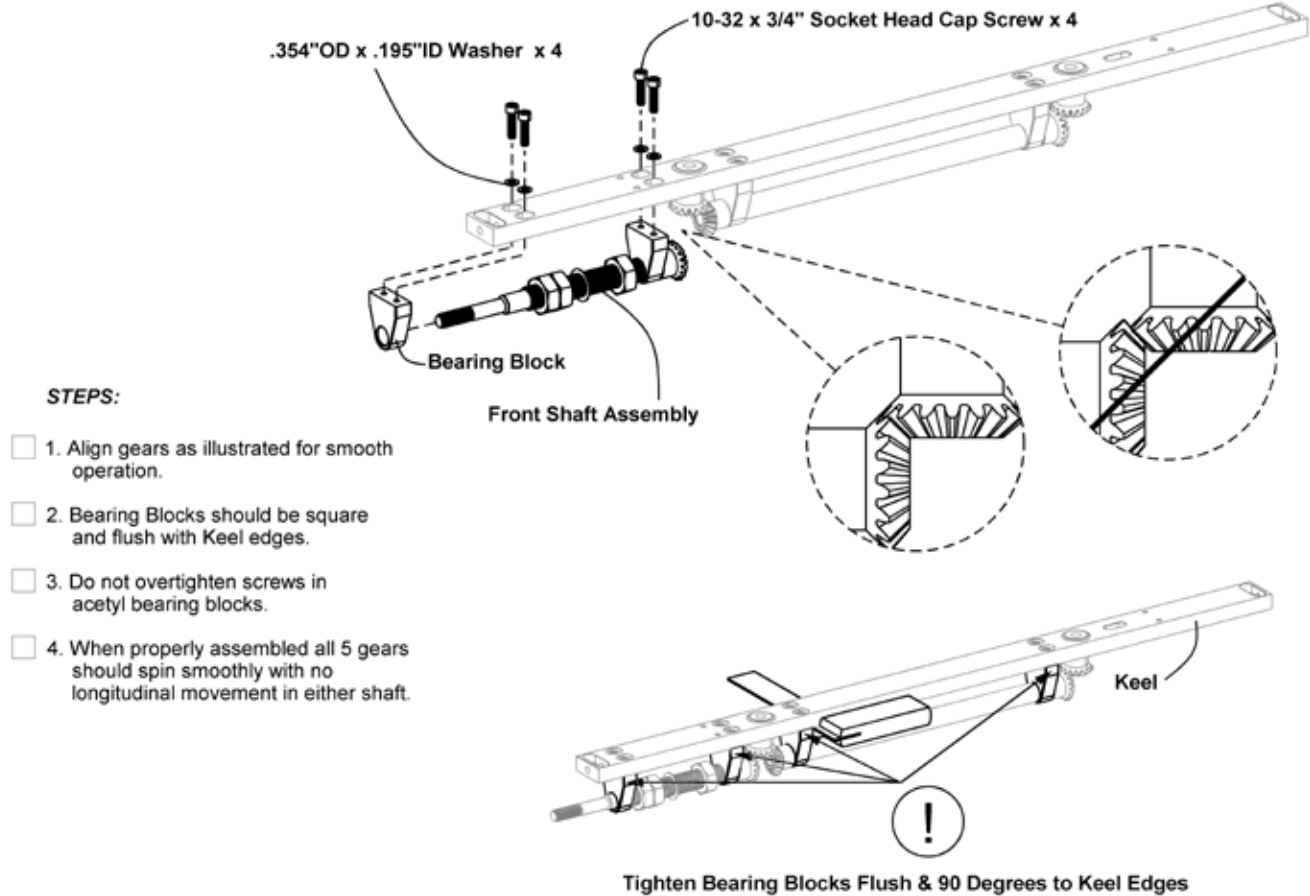
2. REAR SHAFT ASSEMBLY

STEPS:

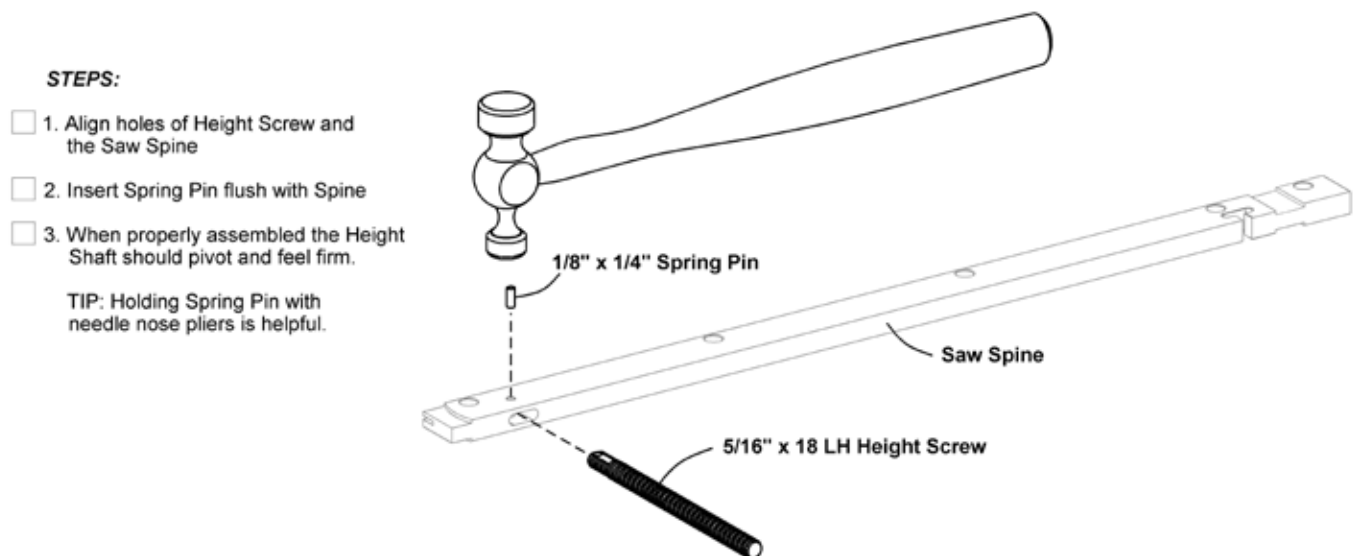
- ☐ 1. Align gears as illustrated for smooth operation.
- ☐ 2. Bearing Blocks should be square and flush with Keel edges.
- ☐ 3. Do not overtighten screws in acetyl bearing blocks.
- ☐ 4. When properly assembled gears should spin smoothly with no longitudinal movement in the rear shaft.



3. FRONT SHAFT TO KEEL



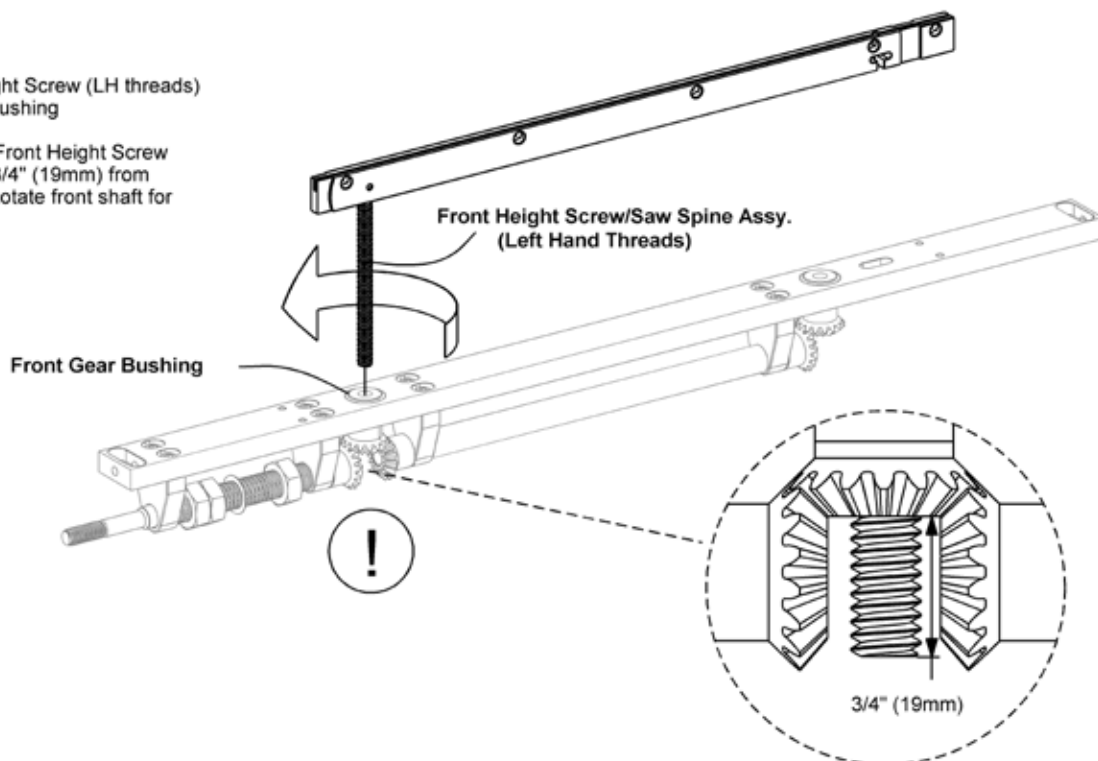
4. FRONT HEIGHT SHAFT TO SPINE



5. SAW SPINE TO KEEL

STEPS:

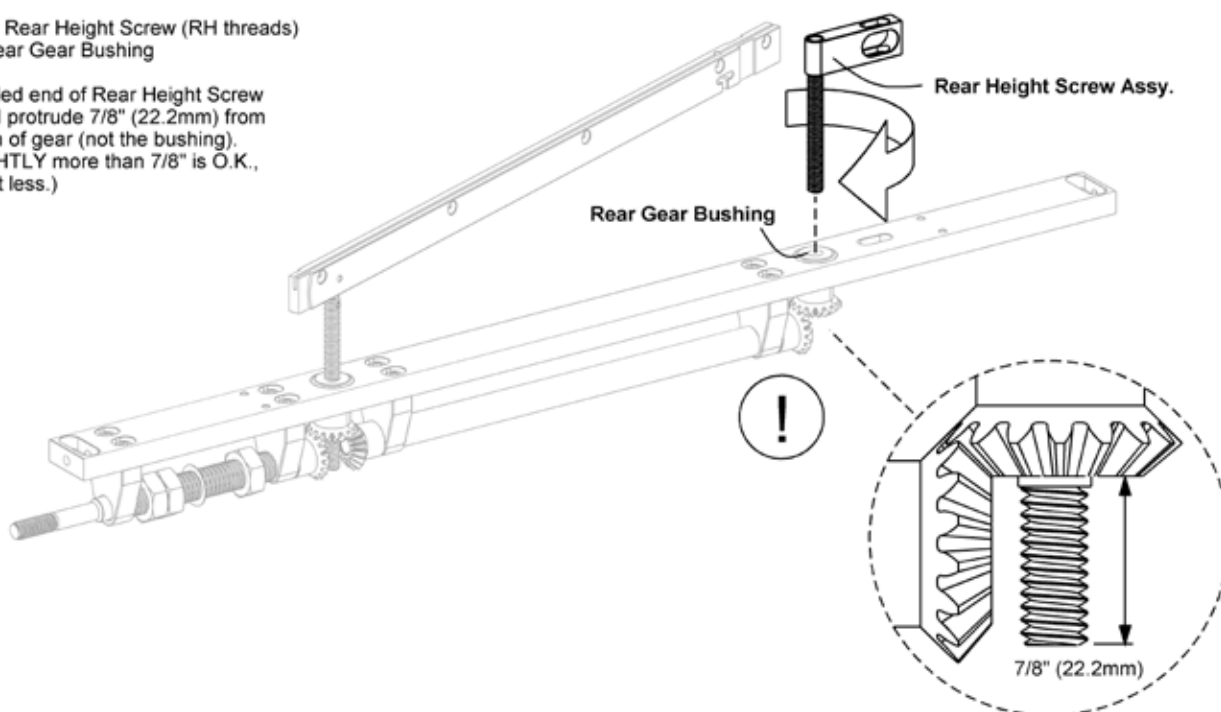
- ☐ 1. Thread Front Height Screw (LH threads) into Front Gear Bushing
- ☐ 2. Threaded end of Front Height Screw should protrude 3/4" (19mm) from bottom of gear. Rotate front shaft for precise setting.



6. REAR HEIGHT SCREW TO KEEL

STEPS:

- ☐ 1. Thread Rear Height Screw (RH threads) into Rear Gear Bushing
- ☐ 2. Threaded end of Rear Height Screw should protrude 7/8" (22.2mm) from bottom of gear (not the bushing). (SLIGHTLY more than 7/8" is O.K., but not less.)

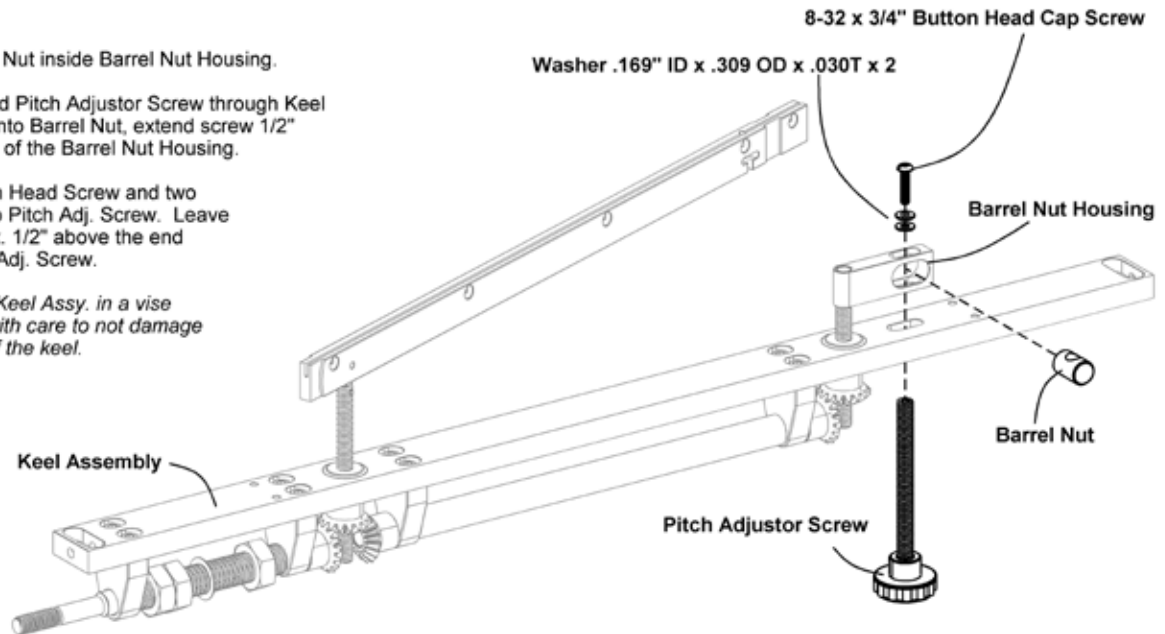


7. PITCH ADJUSTOR ASSEMBLY

STEPS:

- ☐ 1. Place Barrel Nut inside Barrel Nut Housing.
- ☐ 2. Insert Thread Pitch Adjustor Screw through Keel and thread into Barrel Nut, extend screw 1/2" pass the top of the Barrel Nut Housing.
- ☐ 3. Insert Button Head Screw and two washers into Pitch Adj. Screw. Leave head approx. 1/2" above the end of the Pitch Adj. Screw.

HINT: Hold Keel Assy. in a vise if possible with care to not damage the edges of the keel.

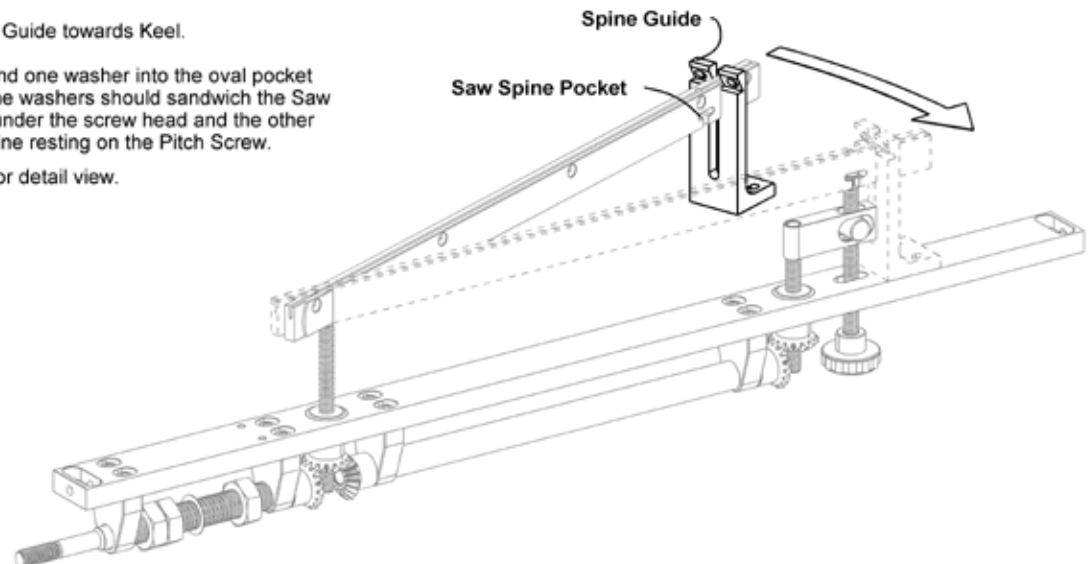


8. REAR SPINE GUIDE

STEPS:

- ☐ 1. Slide Spine Guide onto Saw Spine as shown.
- ☐ 2. Rotate Saw Spine & Guide towards Keel.
- ☐ 3. Slide Button Head and one washer into the oval pocket in the Saw Spine. The washers should sandwich the Saw Spine—one washer under the screw head and the other is under the Saw Spine resting on the Pitch Screw.

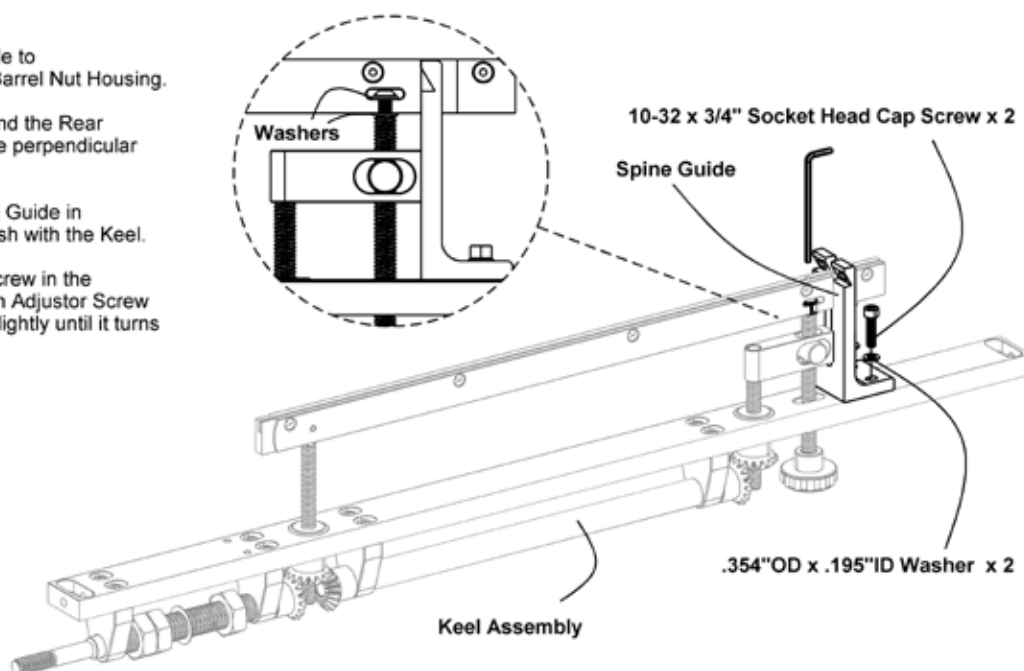
NOTE: See Step 9 for detail view.



9. PITCH ADJUSTOR/SPINE GUIDE

STEPS:

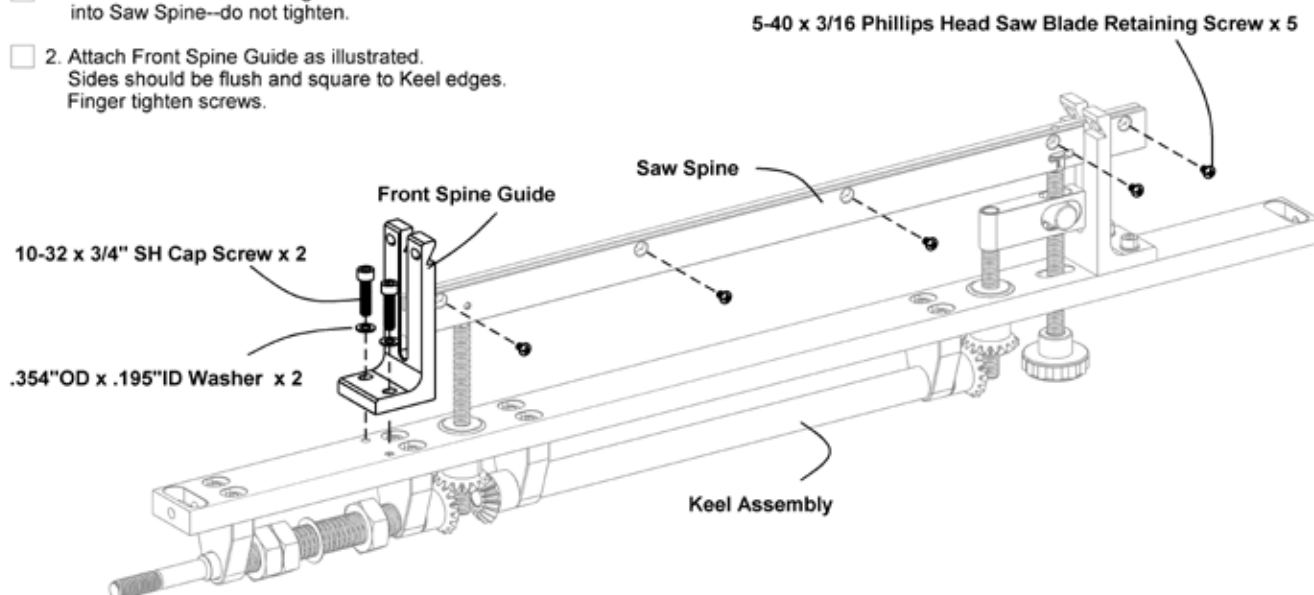
- ☐ 1. Position the Spine Guide to touch the back of the Barrel Nut Housing.
- ☐ 2. The Pitch Adj. Screw and the Rear Height Screw should be perpendicular to the Keel.
- ☐ 3. Tighten the Rear Spine Guide in place with the sides flush with the Keel.
- ☐ 4. Tighten the retaining screw in the Pitch Adj. until the Pitch Adjustor Screw will not turn. Back off slightly until it turns smoothly without slop.



10. FRONT SPINE GUIDE

STEPS:

- ☐ 1. Insert Saw Blade Retaining Screws into Saw Spine—do not tighten.
- ☐ 2. Attach Front Spine Guide as illustrated. Sides should be flush and square to Keel edges. Finger tighten screws.



11. SAW BLADE GUIDES

STEPS:

- ☐ 1. Place one Shim Washer between Front Spine Guide and Black Saw Guide as shown.
- ☐ 2. Attach Black Saw Guide to left side of Front and Rear Spine Guides. The outside face of the Black Saw Guide should be perfectly flush with the outside faces of both Spine Guides.
- ☐ 3. Repeat steps 1 & 2 for Blue Saw Guide

.010" Thick Shim Washer x 2

Front Spine Guide

Keel

Black Saw Guide

.195 ID x .394 OD x .030 T Washer x 4

10-32 x 1/2" Socket Head Cap Screw x 4

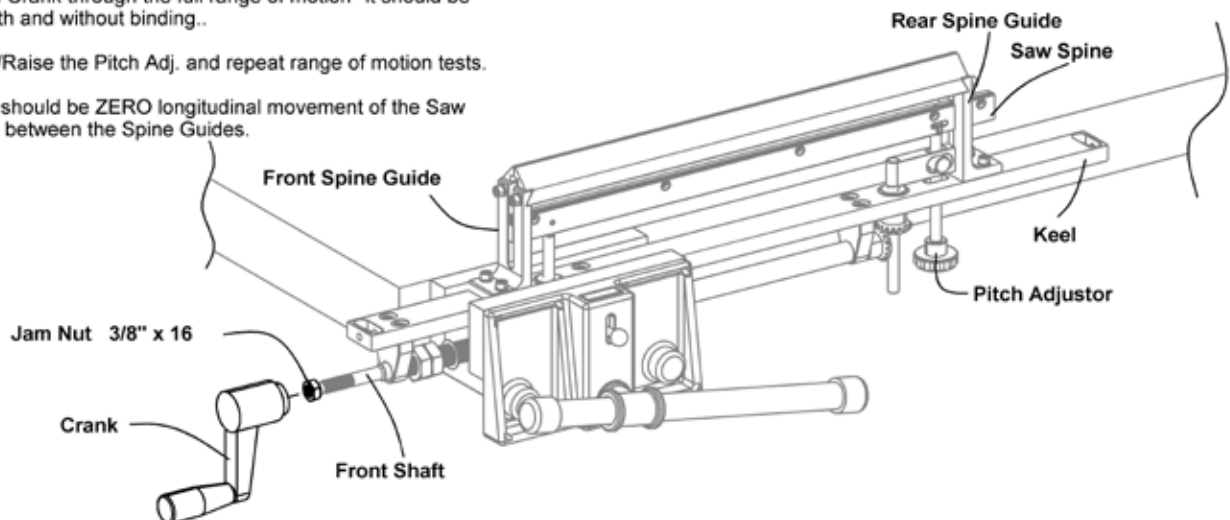
Blue Saw Guide

4. Slide bottom of Front Spine Guide forward to remove all longitudinal play of the Spine between the Spine Guides.
5. Tighten Front Spine Guide to Keel

12. TRANSMISSION CHECK

STEPS:

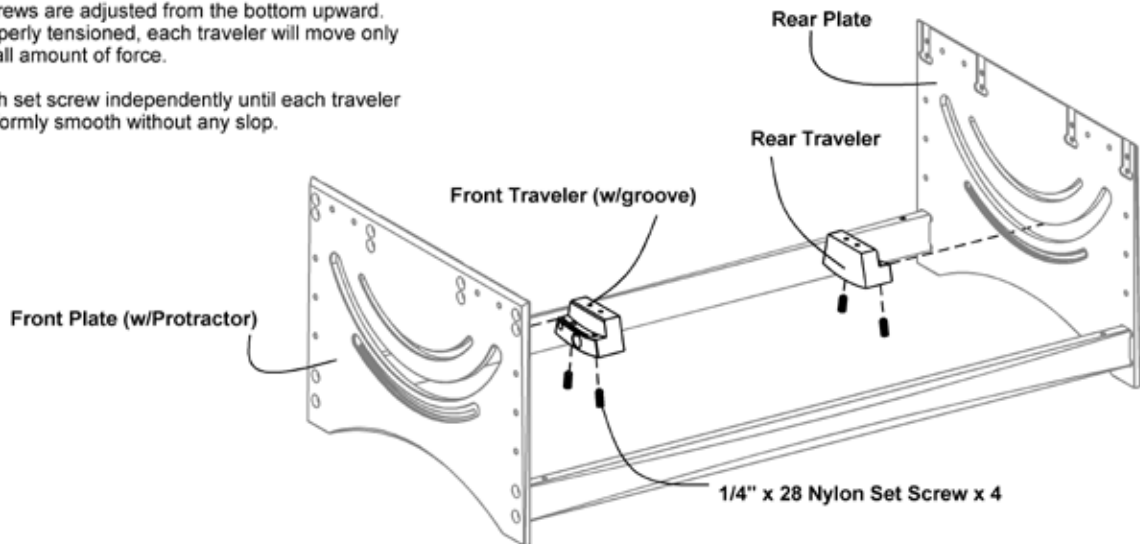
- ☐ 1. Place Keel Assembly in vise (do not damage keel edges).
- ☐ 2. Thread Jam Nut onto Front Shaft
- ☐ 3. Thread Crank onto Front Shaft. Use a wrench to tighten the Jam Nut against the crank.
- ☐ 4. Rotate Crank through the full range of motion--it should be smooth and without binding..
- ☐ 5. Lower/Raise the Pitch Adj. and repeat range of motion tests.
- ☐ 6. There should be ZERO longitudinal movement of the Saw Spine between the Spine Guides.
- ☐ 7. Binding is relieved by adjusting the Spine Guides or by ensuring the bearing blocks are square to the keel.



13. TRAVELERS

STEPS:

- ☐ 1. The friction fit of the travelers in the plate grooves is controlled by two nylon set screws.
- ☐ 2. The set screws are adjusted from the bottom upward. When properly tensioned, each traveler will move only with a small amount of force.
- ☐ 3. Adjust each set screw independently until each traveler works uniformly smooth without any slop.

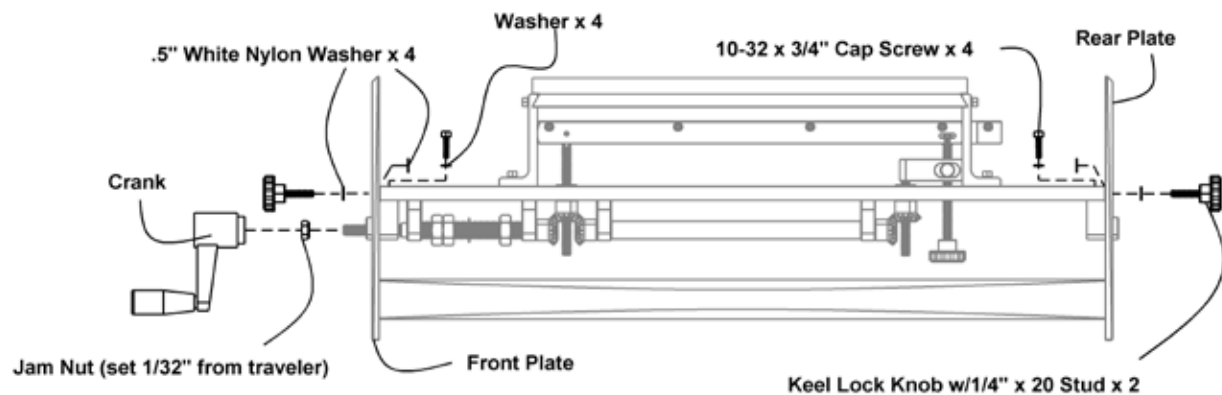
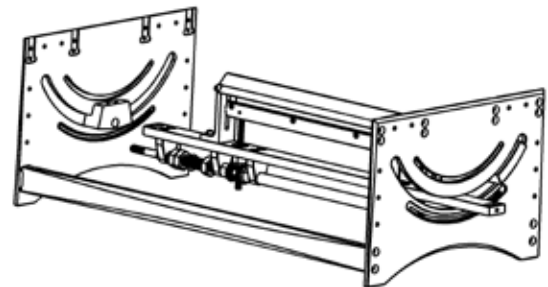


14. KEEL ASSEMBLY TO FRAME

STEPS:

- ☐ 1. Slide rear traveler to end of traveler groove in the rear plate.
- ☐ 2. Insert back of Keel Assembly into the rear plate traveler groove.
- ☐ 3. Move Keel Assy forward so front shaft protrudes through the front traveler and the keel rests on top of the traveler.
- ☐ 4. Slide rear traveler to center position and rest keel assy. on both travelers.
- ☐ 5. Attach all fasteners and hardware as illustrated.

NOTE: Leave Keel Screws and Keel Locking Knobs finger tight only.

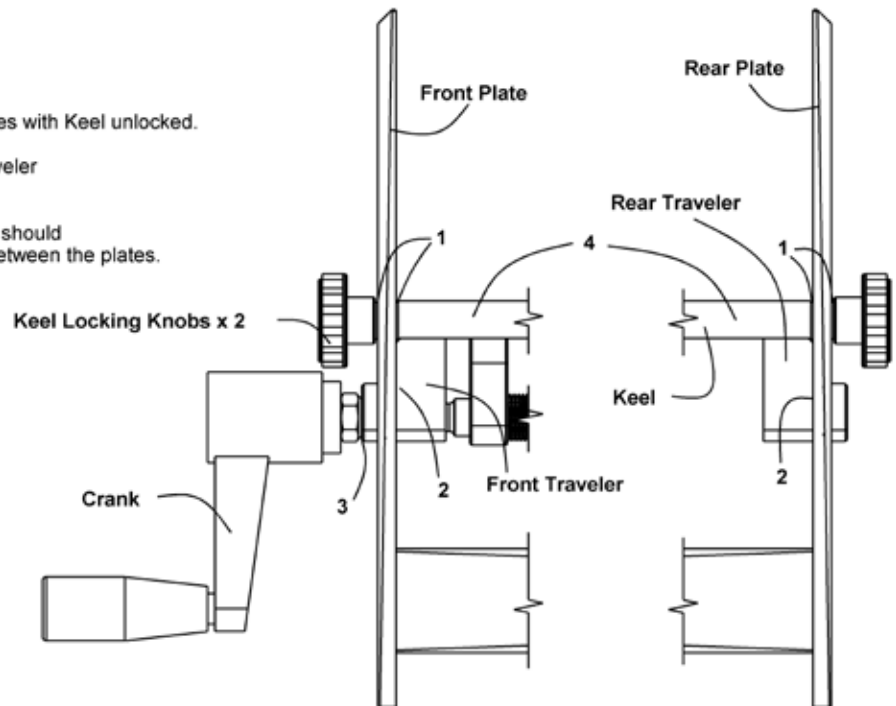


NOTE: See Step 15 for detail view.

15. ASSEMBLY DETAIL

STEPS:

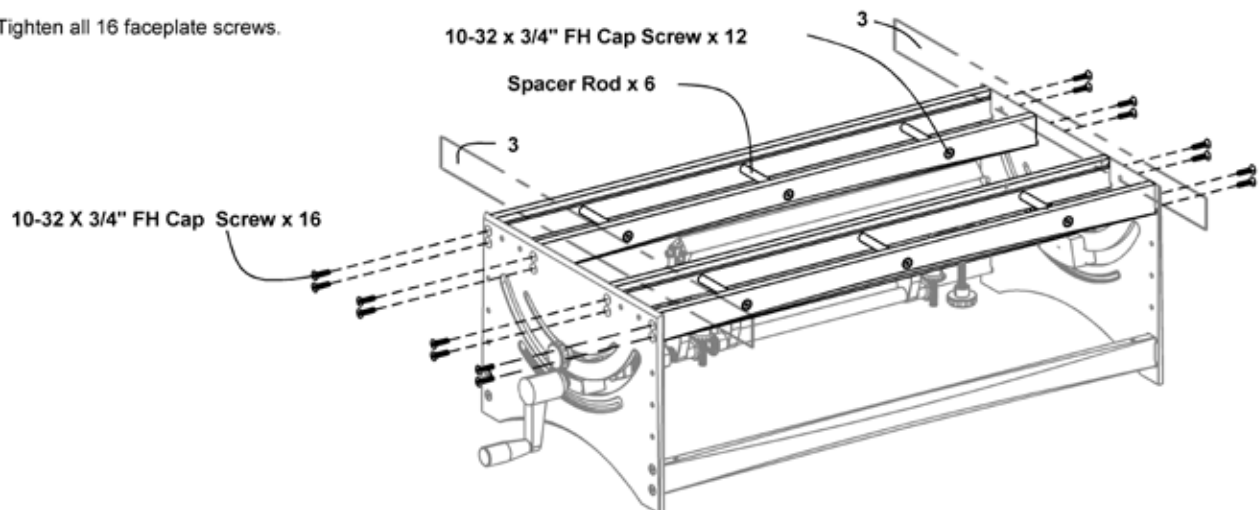
- ☐ 1. Nylon washer locations
- ☐ 2. Both Travelers should be rubbing the plates with Keel unlocked.
- ☐ 3. Jam Nut should NOT touch the Front Traveler (1/32" gap is preferable).
- ☐ 4. With the Keel Locking Knobs loose, there should be ZERO lateral movement of the Keel between the plates.



16. DOVETAIL WAYS

STEPS:

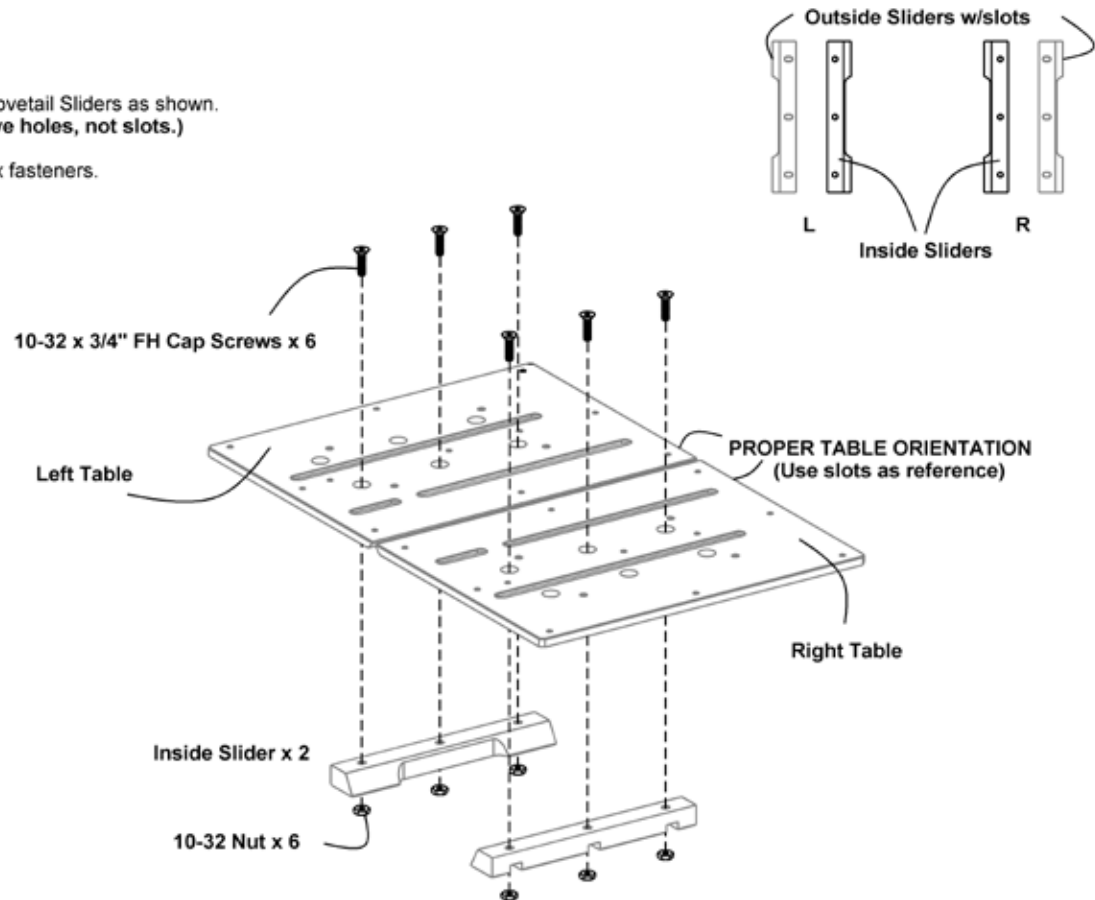
- ☐ 1. Assemble two sets of Dovetail Ways using Way Spacers, do not tighten screws.
- ☐ 2. Fasten Rails into front and rear plate pockets, do not tighten screws.
- ☐ 3. LIGHTLY tighten screws in front/rear plate only after all four ways are planar (use straight edge).
- ☐ 4. Tighten all 12 spacer rod screws.
- ☐ 5. Tighten all 16 faceplate screws.



17. INSIDE DOVETAIL SLIDERS

STEPS:

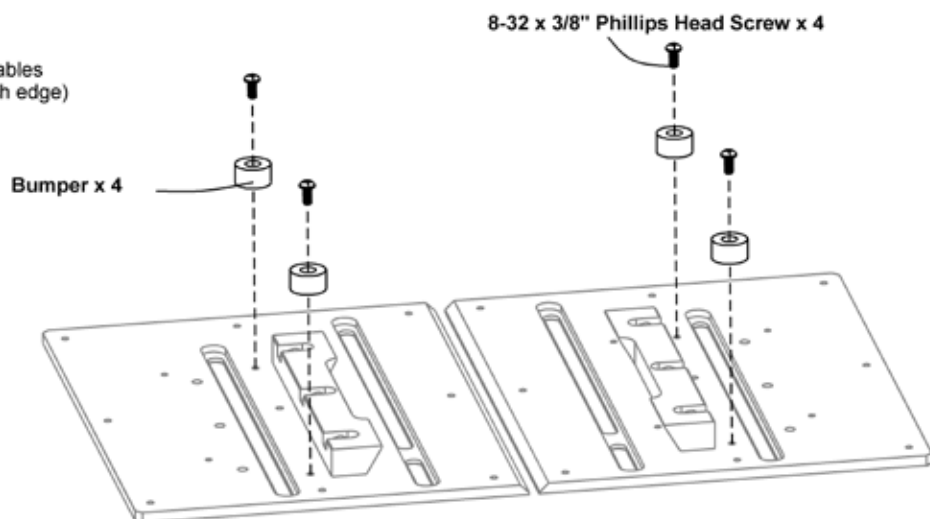
- ☐ 1. Assemble Inside Dovetail Sliders as shown.
(These sliders have holes, not slots.)
- ☐ 2. Firmly tighten all six fasteners.



18. TABLE BUMPERS

STEPS:

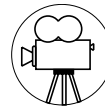
- ☐ 1. Fasten Bumpers to underside of tables
where shown. (2nd hole from each edge)



19. OUTSIDE DOVETAIL SLIDERS

STEPS:

- ☐ 1. Position left table between two way spacers as shown. The inside slider should be engaged with the dovetailed way.
- ☐ 2. Position Outside Slider under table screw holes and install fasteners. DO NOT TIGHTEN.
- ☐ 3. With your palm up, grab the outside slider with your fingers with the butt of your hand on the table edge for leverage.
- ☐ 4. Pull the slider towards you while pushing the table/fixed slider firmly into the adjacent dovetail way. Lightly tighten screws.
- ☐ 5. Slide the table (it should feel too tight) back and forth until the outside slider adjusts to the way for smooth operation.
- ☐ 6. When the table slides smoothly without lateral play tighten screws. Repeat process if necessary.
- ☐ 7. Repeat steps 1-6 for other table.



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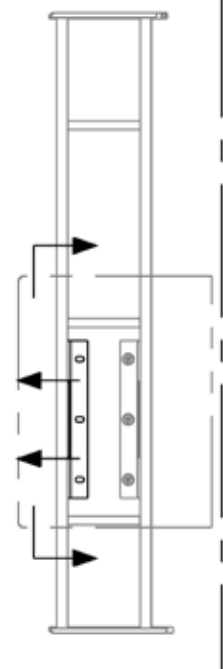
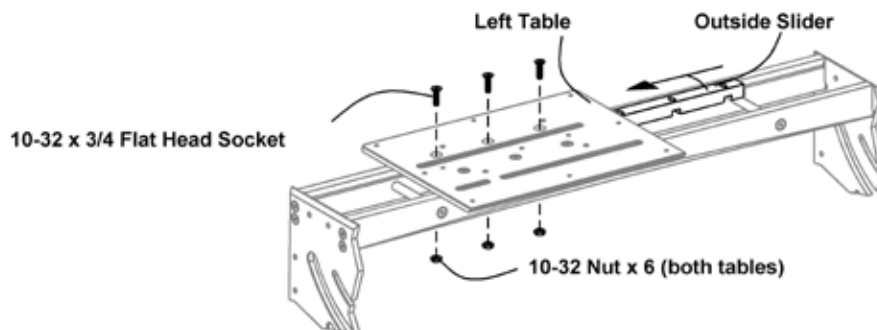
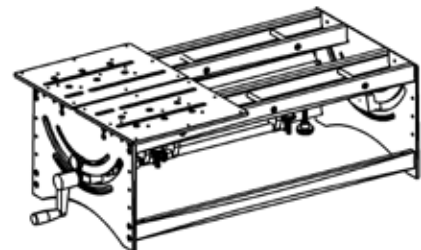
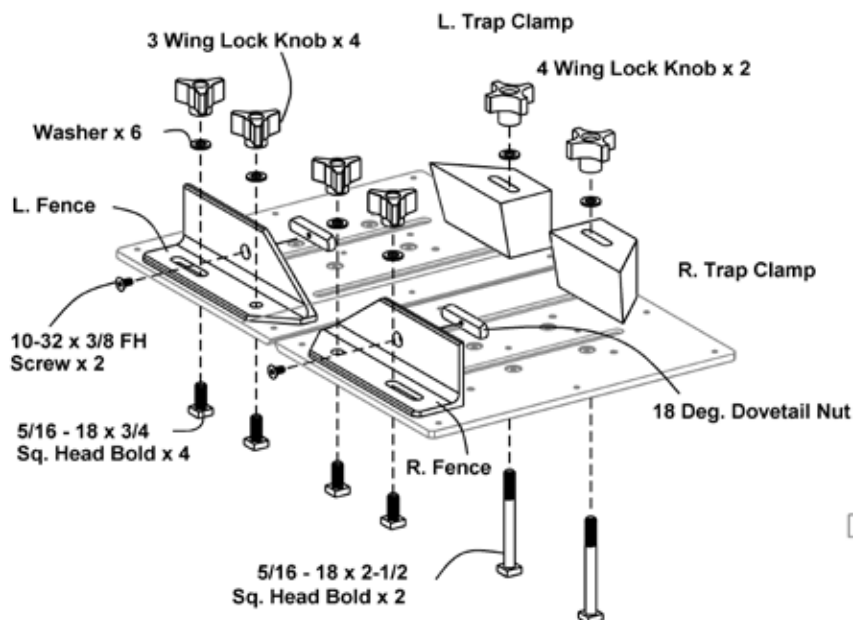


Table Alignment is achieved by pushing table inward while pulling adjustable slider outward with enough pressure for smooth, play free action.

20. FENCE AND TRAP CLAMPS



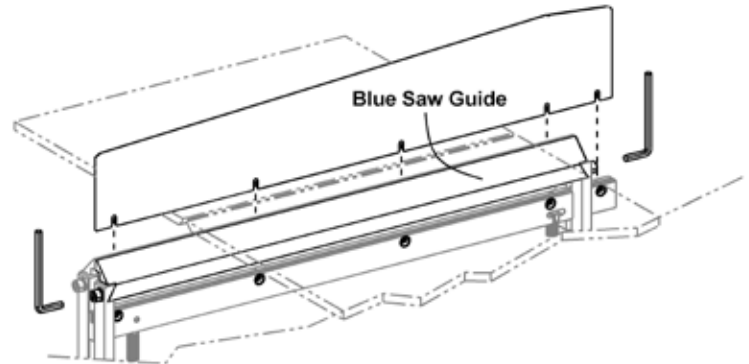
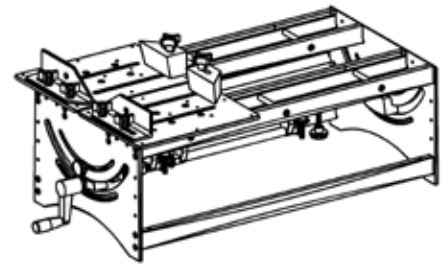
STEPS:

- ☐ 1. Assemble table components as shown. NOTE: The square head of each bolt slides in a slotted recess.

21. SAW BLADE

STEPS:

- ☐ 1. Position both tables as illustrated below.
- ☐ 2. Loosen BLUE Saw Guide. (The Black Guide is never adjusted-- it is a reference surface.)
- ☐ 3. Insert Crosscut Blade and tighten 5 spine screws.
- ☐ 4. Pinch blade between fixed BLACK guide and the adj. BLUE guide. Tighten both screws.
- ☐ 5. Blade should move up and down smoothly.
- ☐ 6. Raise blade to approx. 1/2" above table (front and back).

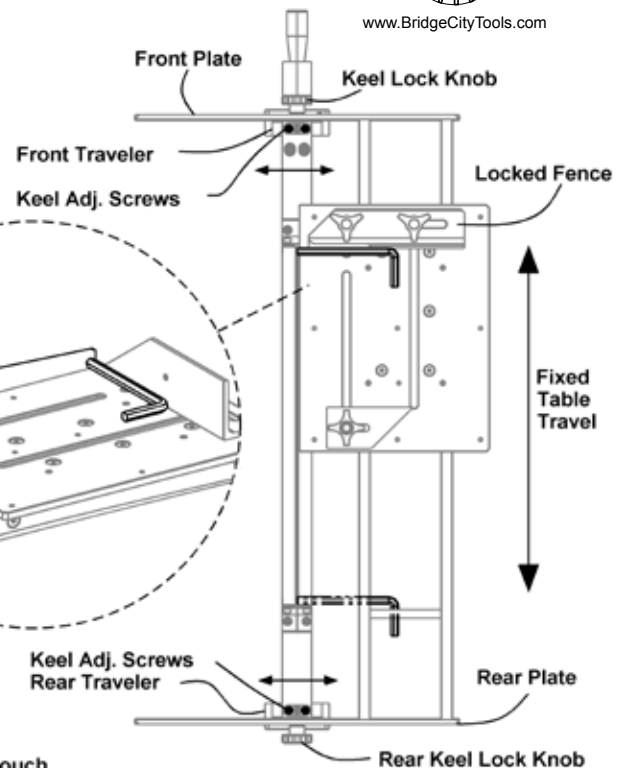
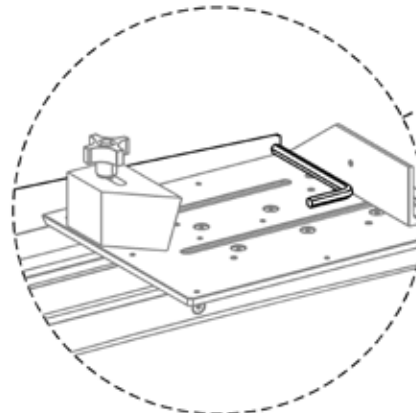


22. BLADE ALIGNMENT

STEPS:

The path of the linear tables and the saw blade need to be precisely parallel for optimal results. Because table travel is non-adjustable, parallelism is accomplished by adjusting the Keel which is fastened to the front and rear travelers with four screws.

- ☐ 1. Temporarily clamp saw to a flat surface under good lighting.
- ☐ 2. Unlock Keel Lock Knobs and adj. blade approximately to 90 degrees. (Adjusting blade angularity is always done by grabbing the center of the Keel, not the rear shaft.)
- ☐ 3. Position a hex key wrench against the locked fence (as illustrated). Lightly touch the end of the wrench to the leading edge of the saw blade.
- ☐ 4. Without changing the position of the wrench, slide table forward and note the location of the end of the wrench at the end of the blade.
- ☐ 5. Adjust the saw blade parallel to table travel by adjusting the keel on the travelers.
- ☐ 6. When properly set, the end of the wrench will just touch the blade at the front and the back the blade without deflecting the blade.
- ☐ 7. Lock then unlock the Keel Lock Knobs.
- ☐ 8. Shift Keel back and forth and return blade to 90 degrees. Lock Keel Knobs and repeat steps 3 & 4. Repeat 5-8 if necessary.

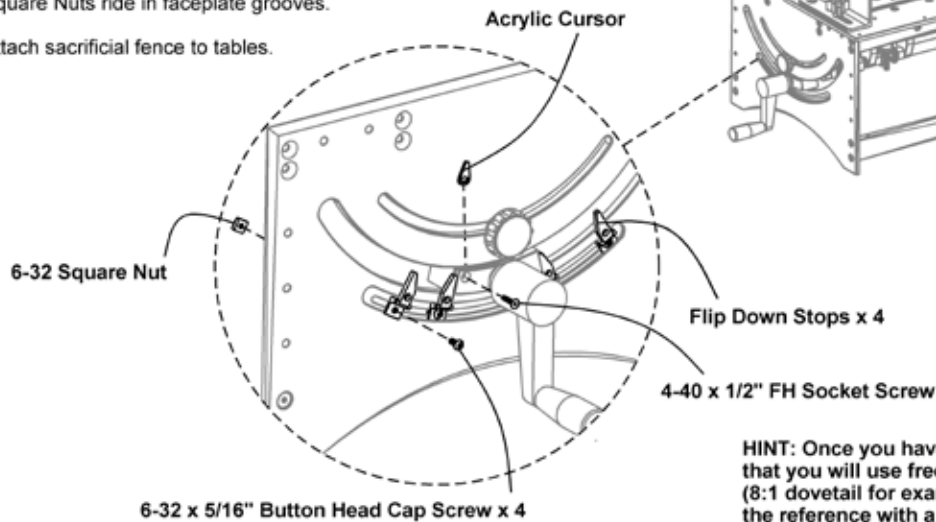


NOTE: When Keel is unlocked, there should be ZERO longitudinal play between the Keel and the front and back plates. Travelers must touch on the inside faces of the front and back plates for angles to repeat. Keep this in mind when adjusting parallelism of blade.

23. CURSOR AND FLIP DOWN STOPS

STEPS:

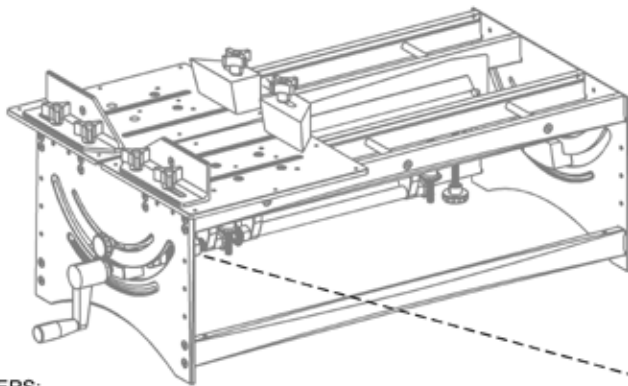
- ☐ 1. Insert acrylic cursor into front traveler groove and secure with screw. (Later, after you have made a cut that is exactly 90 degrees, you can accurately set the position the cursor.) A thin 6" rule is helpful in positioning cursor in slot.
- ☐ 2. Attach Flip Down Stops exactly as illustrated. Square Nuts ride in faceplate grooves.
- ☐ 3. Attach sacrificial fence to tables.



HINT: If the fence feels "stuck" after loosening the locking screws, tap the screws (hex key inserted) to free dovetail nut.

HINT: Once you have set an angle that you will use frequently (8:1 dovetail for example), note the reference with a pencil on the orange stop.

24. BLADE HEIGHT STOP

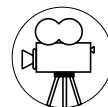
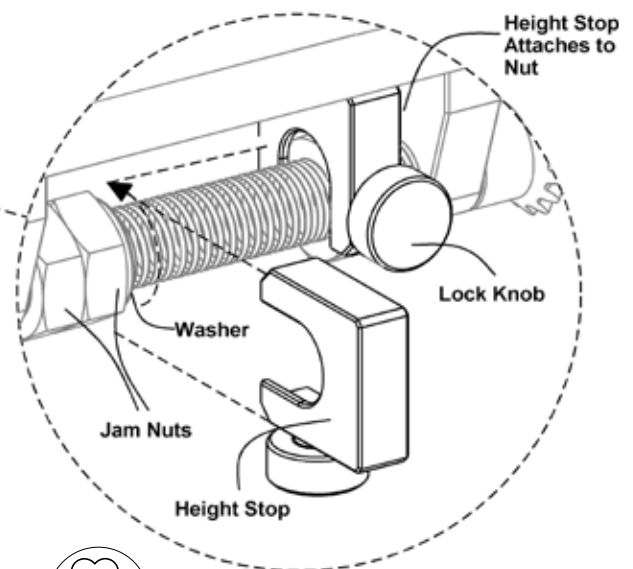


STEPS:

When you want repeatable cuts to a specific depth, attach the red blade height stop as illustrated. Always remove the stop when not required to avoid unnecessary front shaft thread wear.

- ☐ 1. There are three nuts on the front shaft, the two closest to the front plate are jam nuts and the third nut receives the height stop.
- ☐ 2. With the blade at the desired height and pitch, attach the Height Stop as illustrated. The top of the Height Stop should be flush against the bottom of the keel and fully embrace the nut. Tighten Lock Knob.
- ☐ 3. Spin the middle jam nut against the washer until the washer is trapped against the Height Stop face. Finger tight is fine.
- ☐ 4. Using wrenches, tighten the two jam nuts against each other. DO NOT OVERTIGHTEN (aluminum shaft).

- ☐ 5. Blade height will now repeat.
- ☐ 6. Remove Height Stop when not in use to avoid unnecessary thread wear.



25. OPTIONAL STAND

STEPS:

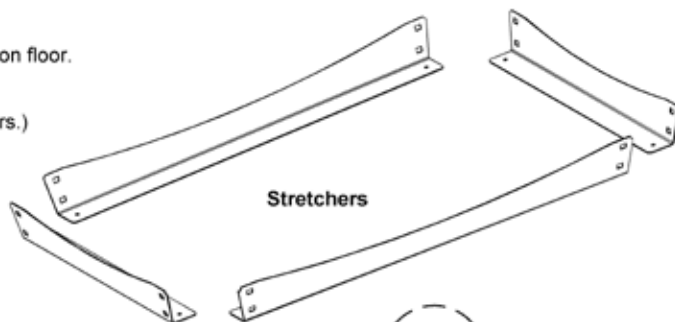
- ☐ 1. Assemble Stand upside-down on bench.
- ☐ 2. Follow the callouts below in numerical order.
- ☐ 3. When stand is completely assembled, invert and set on floor.
- ☐ 4. Attach Jointmaker Pro to top, high side is the back.
(Use 4 mounting holes in Jointmaker bottom stretchers.)
- ☐ 5. Adjust Legs for comfortable working height and tighten all fasteners.

NOTE: For clarity, carriage bolts are not shown. Insert from outside and use washer under nut.

3

Layout four stretchers exactly as shown--the two shorter pieces rest on top of the long pieces. (Each corner is uniquely mated, use corner key pictured above each leg.)

Finger tighten all 16 carriage bolts.



Adj. Legs
Notch Key Location



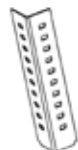
4

Adj. Legs attach to the inside of legs. They too are notch keyed--note location. Same # of holes should protrude from each leg.

Finger tighten all 8 carriage bolts.

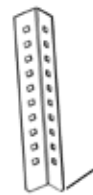


CORNER KEYS



Long Ear

Short Legs



Long Legs

Long Ear

2

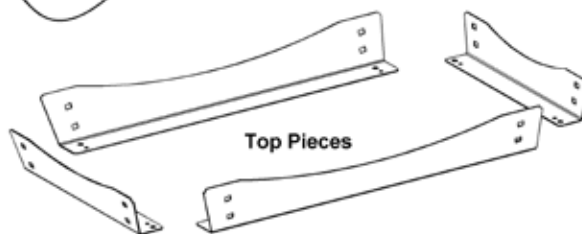
Legs are identified by length and ear direction.

Fasten two long legs to top corners, as shown. Note the position of the long ears.

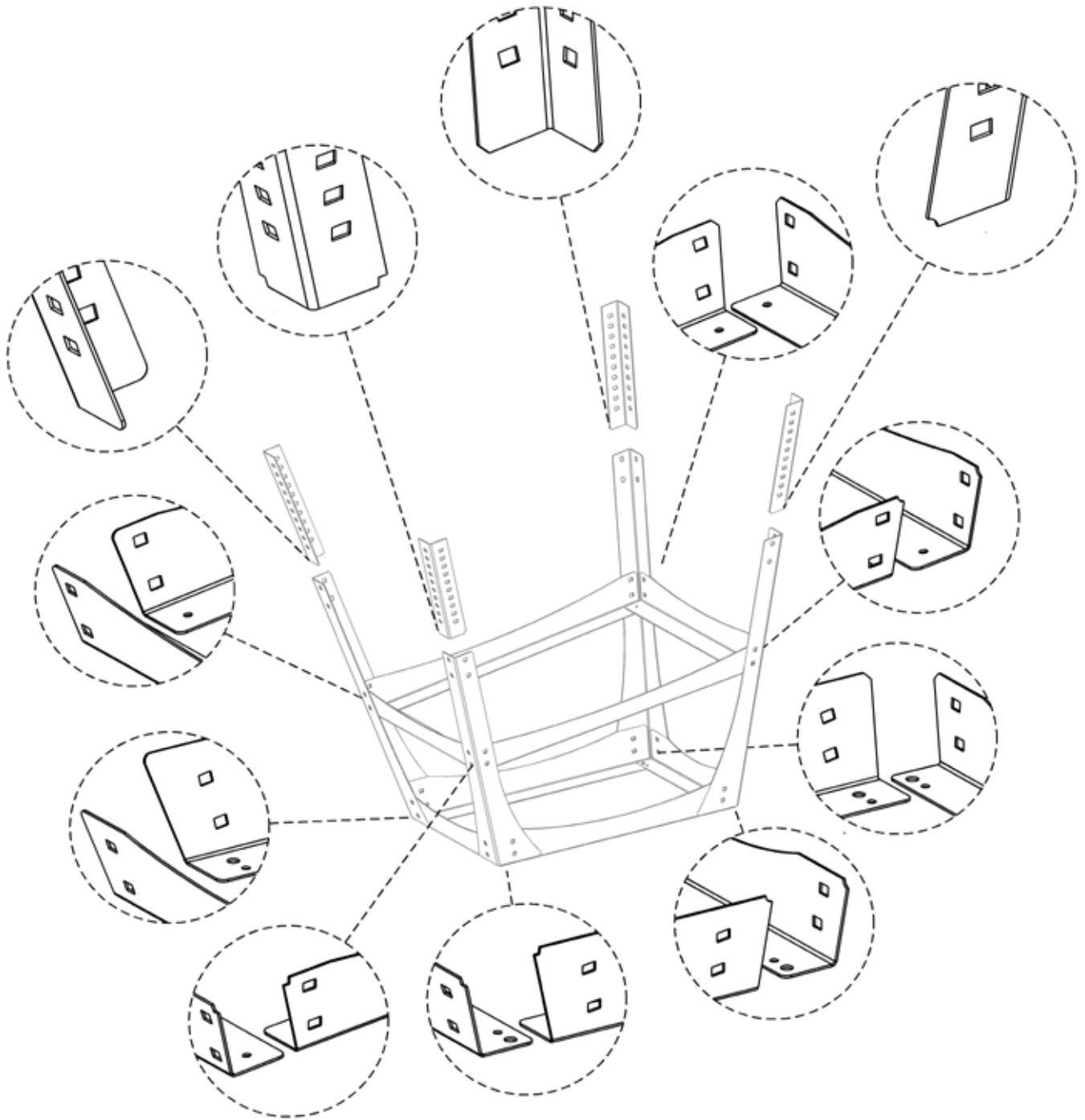
Repeat for Short Legs
Finger tighten all 16 carriage bolts.

1

Layout four top pieces exactly as shown--the two shorter pieces rest on top of the long pieces. (Each corner is uniquely mated, use Corner Key pictured above each leg.)



26. STAND CORNER KEY



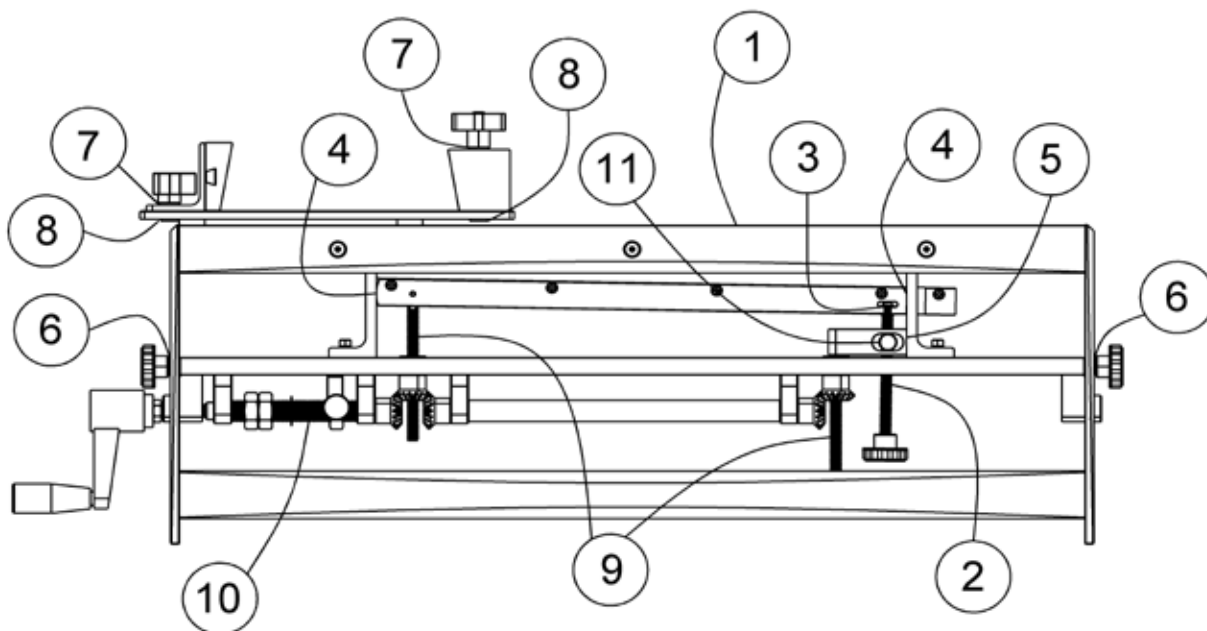
27. LUBRICATION GUIDE

NOTE: The Jointmaker Pro ships with a small tube of teflontm based dri-film lubricant..
It is recommended that you lubricate all indicated moving parts commensurate with use.
The nylon gears do not require lubrication.

Periodically clean all moving parts of saw dust and grime for optimal performance..

STEPS:

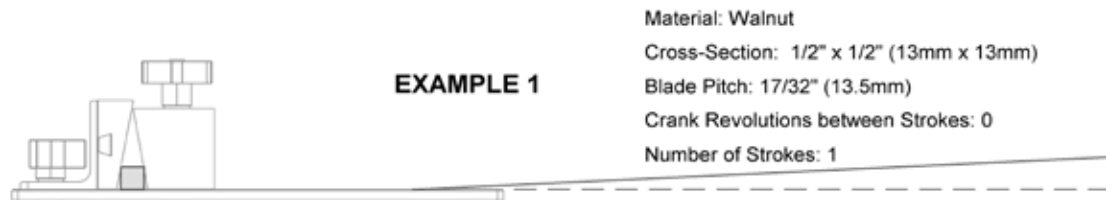
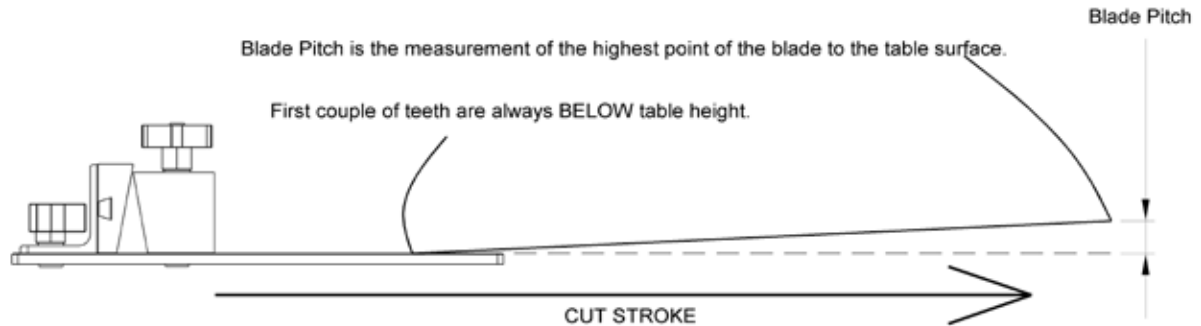
- ☐ 1. Before EACH SESSION, lubricate all four dovetail ways with TEFLONtm based dry film lube (Tri-Flowtm).
Lubricate the bottom of the dovetails and the sliders via the rail lube ports. (Small holes on top of all four rails)
- ☐ 2. Threads of Pitch Adjustor
- ☐ 3. Both Washers that connect the pitch adjustor to the spine.
- ☐ 4. Bearing surface of the spine to the spine guide.
- ☐ 5. Bearing surface barrel nut housing to the spine guide.
- ☐ 6. Threads of the keel lock knobs.
- ☐ 7. Lock knob threads
- ☐ 8. All square head bolt heads.
- ☐ 9. Height screws
- ☐ 10. Front shaft when height stop is used.
- ☐ 11. Barrel Nut outside diameter.



CUTTING GUIDE

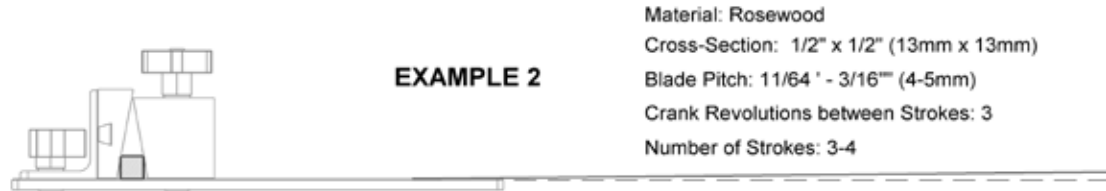
Use the following guidelines to determine the working relationship between blade pitch, material length and material density. These three variables determine the number of full (or partial) cranks required for a through cut.

Generally speaking, the smaller the cross-section the greater the pitch. As the cross-section lengthens, pitch decreases and the number of strokes and crank revolutions increases to complete the cut.



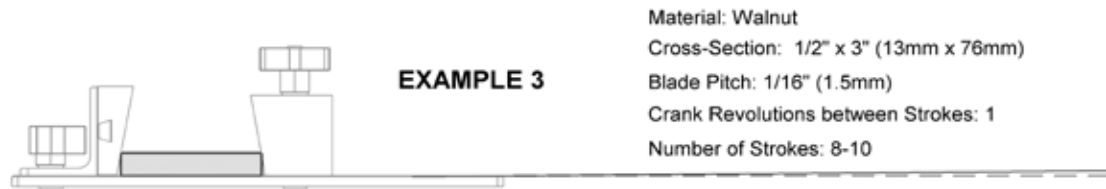
EXAMPLE 1

Material: Walnut
Cross-Section: 1/2" x 1/2" (13mm x 13mm)
Blade Pitch: 17/32" (13.5mm)
Crank Revolutions between Strokes: 0
Number of Strokes: 1



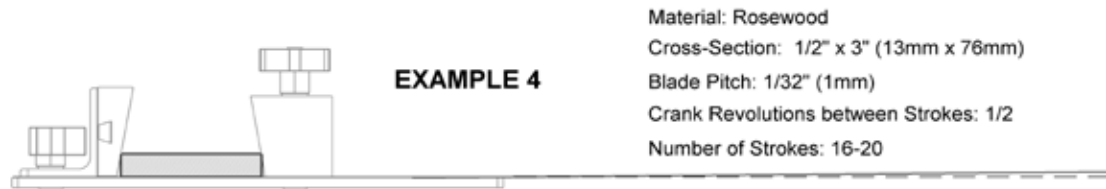
EXAMPLE 2

Material: Rosewood
Cross-Section: 1/2" x 1/2" (13mm x 13mm)
Blade Pitch: 11/64" - 3/16" (4-5mm)
Crank Revolutions between Strokes: 3
Number of Strokes: 3-4



EXAMPLE 3

Material: Walnut
Cross-Section: 1/2" x 3" (13mm x 76mm)
Blade Pitch: 1/16" (1.5mm)
Crank Revolutions between Strokes: 1
Number of Strokes: 8-10

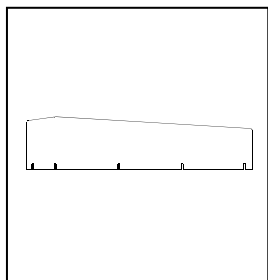


EXAMPLE 4

Material: Rosewood
Cross-Section: 1/2" x 3" (13mm x 76mm)
Blade Pitch: 1/32" (1mm)
Crank Revolutions between Strokes: 1/2
Number of Strokes: 16-20

NOTES

JM-P ACCESSORIES



Rip Blade blades 1101-201RB6

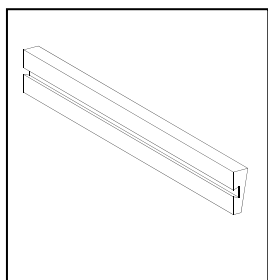
Rip Blade blades 1101-201RB3 (5 Pack)

Cross Cut B 32 TPI blades 1101-201RB2 (5 Pack)

Cross Cut B 32 TPI blades 1101-201RB5

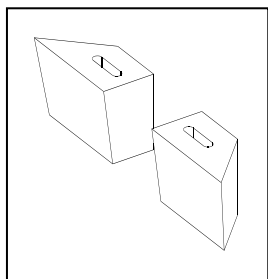
Cross Cut A 28 TPI blades 1101-201RB4

Cross Cut A 28 TPI blades 1101-201RB1 (5 Pack)



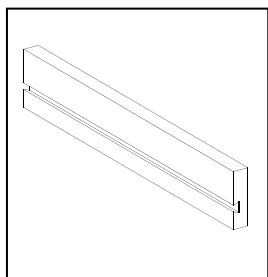
Trap Fence

1101-201-02



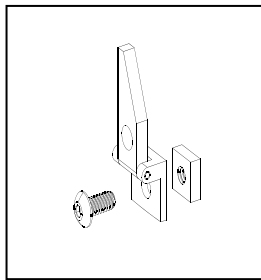
Trap Jaws, Left and Right

1101-201-01

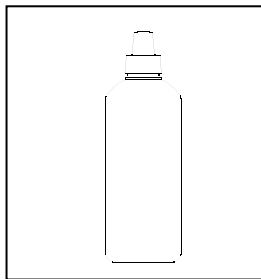


Straight Fence

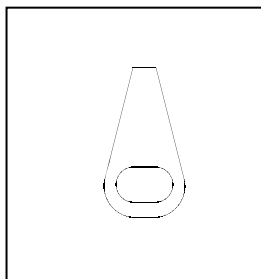
1101-201-03



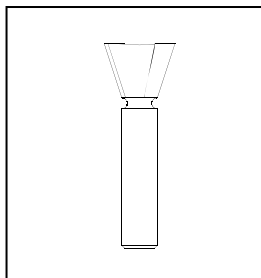
Finger Stops (4 pack) 1101-201-07



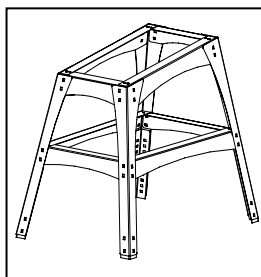
Teflon™ Lube 2 oz. 1101-201-04



Indicator 1101-201-05



18 degree Dovetail Router Bit 1101-201-06
1/4" Shank, 1/2" OD



JMP - Stand 1101-201B

SATISFACTION GUARANTEE

If, for any reason, you are not 100% satisfied with your purchase, simply contact us WITHIN 90 DAYS of receipt for possible remedies, including return instructions. Should you require a return authorization, please contact us for packaging requirements. DO NOT DISASSEMBLE your Jointmaker Pro.

For our full return/repair policy, please refer to our website.
www.BridgeCityTools.com



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